

Date: Monday, 6/2/2008 2:40:32 PM
 User: Chantal Lavoie

Process Sheet

198

Customer	: CC-DAR01	Dart Aerospace Ltd.	Drawing Name	: BACK LEG ASSEMBLY
Job Number	: 39649		Part Number	: D3782045
Estimate Number	: 13323		Drawing Number	: PROTO
P.O. Number	:		Project Number	:
This Issue	: 6/2/2008	S.O. No. :	Drawing Revision	: PROTO
Prsh Rev.	: NC		Material	:
First Issue	: / /	Type : R & D SM/MED FAB	Due Date	: 6/9/2008
Previous Run	: 05011			
Written By	:			Qty: 2 Um: Each
Checked & Approved By	:			
Comment	: Est Rev:A 08-05-19 new issue DD verified by:ec			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1		
	Pick Packing Kit		
2.0	D37721	Back Leg	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Back Leg		
	batch: B38888		
3.0	D37871	Foot	
		BELL P/N205-070-786-001	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Foot		
	batch: B39634		
4.0	D37641	Back Leg Fitting	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Back Leg Fitting		
	batch: B39109		
5.0	D3773041	Headrest Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Headrest Assembly		
	batch: B05004		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BACK LEG ASSEMBLY

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Seq. #:	Machine Or Operation:	Description :
6.0	AN515A	Bolt
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Bolt batch: M108077	7/6 080603
7.0	AN4515A	EYE BOLT
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	EYE BOLT batch: M107938	7/6 080603
8.0	AN517A	Bolt
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Bolt batch: M106815	7/6 080603
9.0	AN415A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Bolt batch: M107737	7/6 080603
10.0	NAS1149F0463P	Washer
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)	
	Washer batch: M5519	7/6 080603
11.0	NAS1149F0563P	Washer
	Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Washer batch: M108099	7/6 080603
12.0	MS21042L4	Nut
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Nut batch: M107478	7/6 080603

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: BACK LEG ASSEMBLY

Job Number: 39649

Part Number: D3782045

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0 MS21042L5

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

batch: M107464

STK

080603

14.0 D37861

Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Sleeve

batch: B39350

STK

080603

15.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3782

STK

080603

PTO →

16.0 QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING APPROVAL ENG-G APPROVAL
08.06.03

Comment: INSPECT WORK TO CURRENT STEP

17.0 PACKAGING 1

PACKAGING RESOURCE #1



STK
08.06.03

Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock Location: _____

18.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.03 Prototype

Job Completion



in 08.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.06.03	15	D3772-1 interior was machined $\phi 1.010"$ x 2 3.25" DEEP ON BOTH ENDS TO ALLOW INSTALLATION OF D3773-041 and D3786-1	P&F	08.06.03	ALL	P&F 08.06.03	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

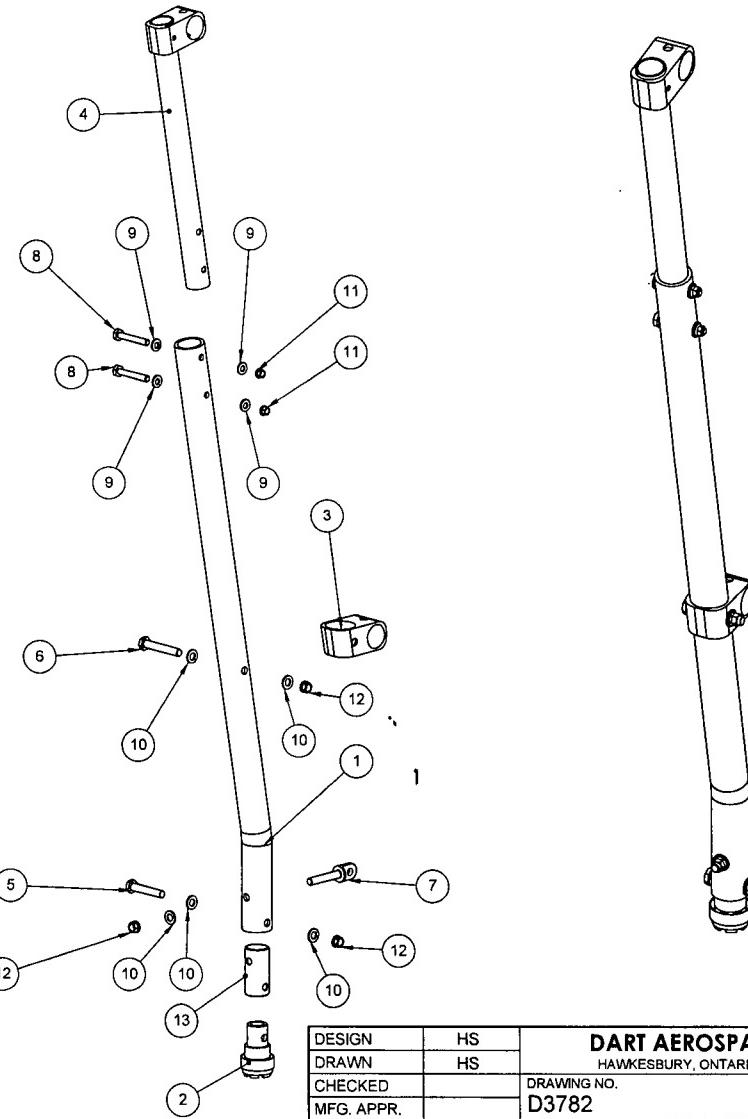
NOTE: Date & initial all entries

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3772-1	BACK LEG	1
2	D3787-1	FOOT	1
3	D3764-1	BACK LEG FITTING	1
4	D3773-041	HEAD REST ADAPTER ASSY	1
5	AN5-15A	BOLT	1
6	AN5-17A	BOLT	1
7	AN45-15A	EYE BOLT	1
8	AN4-15A	BOLT	2
9	NAS1149F0463P	WASHER	4
10	NAS1149F0563P	WASHER	5
11	MS21042L4	NUT	2
12	MS21042L5	NUT	3
13	D3786-1	SLEEVE	1

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.06.02 RF

D3782-045 BACK LEG ASSY

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A



DESIGN DRAWN	HS HS	DART AEROSPACE LTD	
CHECKED		HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.		DRAWING NO.	REV. A
APPROVED		D3782	SHEET 4 OF 4
DE APPR.		TITLE	SCALE
DATE	08.05.15	LEG ASSEMBLY	1:1

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